

Work Order ID 63685

November 10, 2010 8:55:17 AM

Page 1

Item ID: D4176-3

Accept

Revision ID:

Item Name: 429 Clamp, Bottom

Start Date: 11/10/10 Start Qty: 10.00

Required Date: 11/15/10 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4176

A

100

0.00



Waterjet

FLOW CNC Waterjet

304.020

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

FB 10-11-11

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

FB 10-11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63685

November 10, 2010 8:55:17 AM

Page 2

Item ID: D4176-3

Accept

Setup Start

Revision ID:

Stop

Item Name: 429 Clamp, Bottom

Start Date: 11/10/10 Start Qty: 10.00

Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

8.01.11.11

(7.0)

130

Form as per dwg

0.00

Brake NC

Memo

0.00

Brake NC

SB 10/11/12

(10)

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8.01.11.12

(7.0)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63685

November 10, 2010 8:55:17 AM

Page 3

Item ID: D4176-3

Accept

Revision ID:

Item Name: 429 Clamp, Bottom

Start Date: 11/10/10 Start Qty: 10.00

Required Date: 11/15/10 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

150

Identify as per dwg & Stock Location: 460

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/12 (10)

10/11/15

10-11-12 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 10, 2010 8:55:16 AM

Page 1

Work Order ID: 63685

Parent Item: D4176-3

Parent Item Name: 429 Clamp, Bottom



Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.09.29 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased			No	100	sf	101.2108	0.0025	0.026316			



304SS sheet .080



1810-11-21

Location

Loc Qty

Loc Code

MAT20

101.2108

113295

101.2108

113295

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63685
Description: 429 CLAMP BOTTOM	Part Number:	D4176-3
Inspection Dwg: D4176-3, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

x	Prototype
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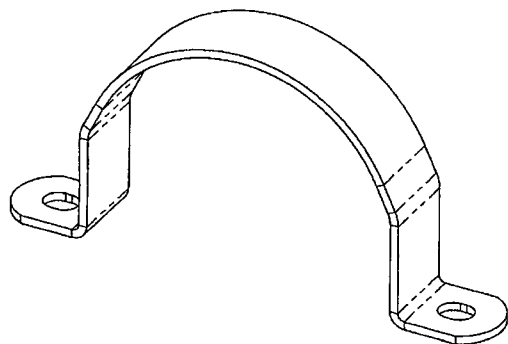
[illegible]

Measured by:	B
Date:	10-11-11

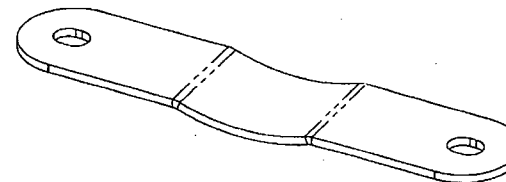
Audited by:	8
Date:	10/11/11

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4176-1 429 CLAMP, TOP



D4176-3 429 CLAMP, BOTTOM

*WLO
63685*

RELEASED
2010-10-07
MB

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

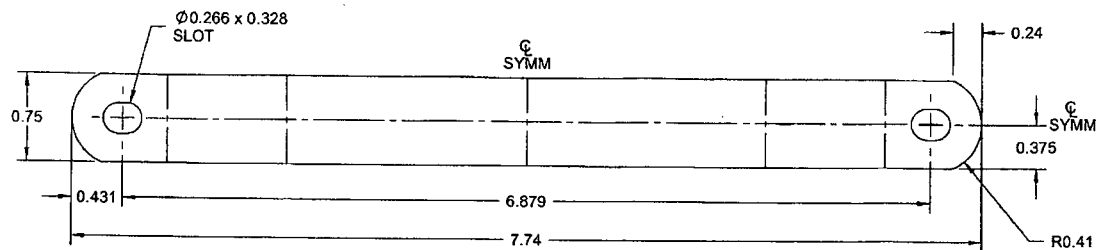
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4176-X" PER QSI 044 6.1

7) WEIGHT:

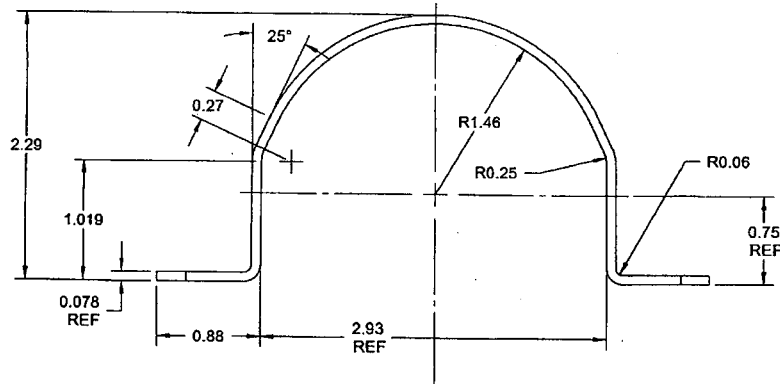
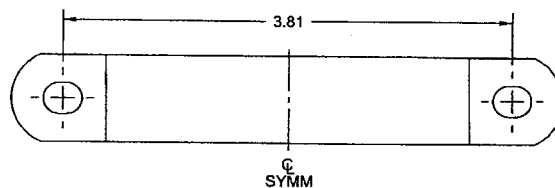
- D4176-1 = 0.12 lbs

- D4176-3 = 0.08 lbs

A	NEW ISSUE	MB	10.09.27
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4176	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		429 CLAMP	NTS
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D4176-1F 429 TOP CLAMP FLAT PATTERN

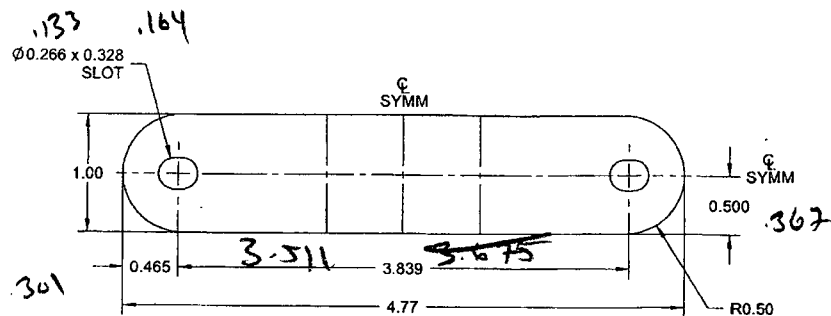


D4176-1 429 CLAMP, TOP
(MAKE FROM D4176-1F)

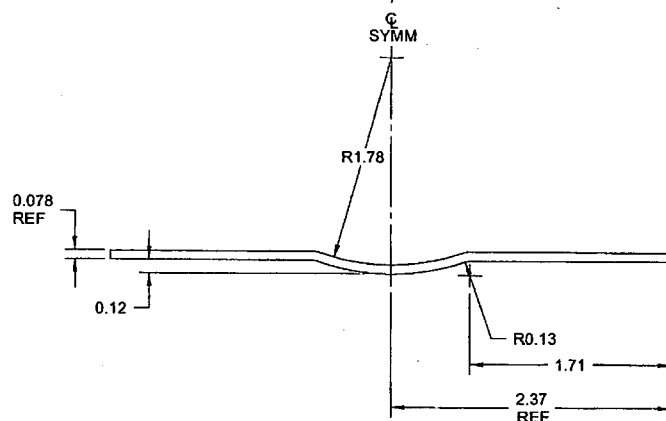
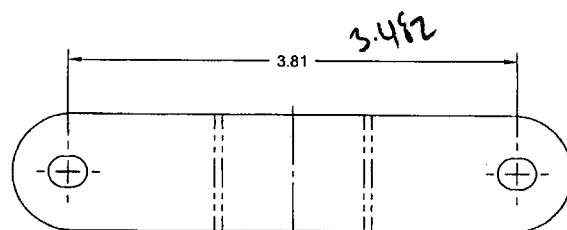
63685

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2010-10-07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4176	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE 429 CLAMP	SCALE
DE APPR.			NTS
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D4176-3F 429 BOTTOM CLAMP FLAT PATTERN



D4176-3 429 CLAMP, BOTTOM
 (MAKE FROM D4176-3F)

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MFG. APPR.		D4176	SHEET 3 OF 3
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RELEASED
 2010-10-03
 NM